

Work Order ID 117156

117156

Page 1

April-24-14 9:59:00 AM

Item ID: D4804-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bipod Assembly, Aft
Start Date: 5/02/14 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 5/02/14 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: MCS Date: 11-04-29 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4804	<u>A</u> <u>B</u> <u>C</u>

11.06.18

110 0.00

110

Small Fab

Small Fab

Memo

0.00

ALIGN PILOT HOLES IN D4807-041 WITH PILOT HOLES IN D4804-1.
ALIGN PILOT HOLES IN D4808-041 WITH PILOT HOLES IN D4804-1.
DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER DWG.
REAM EACH HOLES USING REAMER, USING DART TOOL SETUP
DT9954 AS PER DWG.

DEC 10 2014

120

QC5- Inspect part completeness to step on W/O 0.00

120

QC

Quality Control

Memo

0.00

DAS
38
9-89

DEC 15 2014

Punch.
rec'd

issue pro to P+L

P/O: 26854

C214/12/18 ①

1X SP15-01-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Work Order ID 117156

April-24-14 9:59:00 AM

117156

Page 2

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Revision ID: Stop ***NS2***
Item Name: Bipod Assembly, Aft
Start Date: 5/02/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/02/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Small Fab

Memo

0.00

Small Fab

INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL
WET AS PER DWG USE DT9954
A/R HYSOL BATCH: 17131002

1 FF DEC 16 2014

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

① DAS
38
9-89
DEC 16 2014

150

Identify as per dwg & Stock Location: 87 236 0.00***150***

Packaging

Memo

0.00

Packaging

1x DAS
28
9-89
JAN 21 2015
1x 87150120

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Equip/Tooling									
Handling/Prep									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MW 15-01-22

15-1-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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April-24-14 9:59:02 AM

117156

D4804-041

Start Date: 5/02/14**Required Date:** 5/02/14**Start Qty: 1.00**

Required Qty: 1.00

IPP REV:A 14.01.16 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4804-1		Manufactured	No				Each	0.0000		2			
D4804-1 Strut 117315 B-127486													
D4807-041		Manufactured	No				Each	2.0000		1			
D4807-041 Support Assembly 117320													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST144			2						
				111664			2						
D4808-041		Manufactured	No				Each	0.0000		2			
D4808-041 Rod End Bearing Assembly 116516													
HL20PB5-8		Purchased	No				Each	76.0000		8			
HI 20PB5-8 Rivet HL32PB5-8													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST281	M129865		66			8			
					M128110		6						
					M128579		60						
				ST284			10						
					M128429		10						

DQA: _____ Date: _____



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FAULT CATEGORY

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Picklist Print

Page 2

April-24-14 9:59:02 AM

Work Order ID: 117156

117156

Parent Item: D4804-041

D4804-041

Parent Item Name: Bipod Assembly, Aft

Start Date: 5/02/14

Required Date: 5/02/14

Start Qty: 1.00

Required Qty: 1.00

HL86-5

Purchased

No

Each

113.0000

8

HI 86-5

FF

DEC 16 2014

Collar

Location

Loc Qty

Loc Code

ST280 M129864

16

M128110

16

ST284

97

M128228

97

8

April-24-14 9:59:02 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE January 14, 2015

P.O NUMBER PO26854

ITEM DESCRIPTION	QUANTITY	COMMENTS
✓ D4804-041 BIPOP ASSEMBLY	1	ALL ITEMS HAVE BEEN LASER MARKED
D4868-042 LEG ASSEMBLY	2	
D4803-041 LEG ASSEMBLY	2	
D4868-041 LEG ASSEMBLY	2	
D4834-042 LEG ASSEMBLY	2	



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

Invoice

Number: 7524

Date: January 14, 2015

Bill To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

PO Number	Terms	Ship Via
26854		

Description	Quantity	Price	HST	Amount
Laser Metal Marking, D4804-041 ✓	✓ 1.00	4.00	✓	4.00
Laser Metal Marking, D4868-042	2.00	4.00	✓	8.00
Laser Metal Marking, D4803-041	2.00	4.00	✓	8.00
Laser Metal Marking, D4868-041	2.00	4.00	✓	8.00
Laser Metal Marking, D4834-042	2.00	4.00	✓	8.00
Sub-Total				\$36.00
13.00% on 36.00				4.68
Total				\$40.68

*Whatever we make, we make it the best we possibly can.
We make it as good as if we were going to keep it for ourselves.*

H.S.T. No. 13301 4258

2% INTEREST CHARGED ON OVERDUE ACCOUNTS
PAY BY INVOICE NO STATEMENT WILL BE ISSUED

Thank You



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO26854**

Purchase Order Date 12/18/2014

PO Print Date 12/18/2014

Page Number 1 of 3

Order From :

VC-PL001

P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-931-1241

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

PAID

8415-01-20

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extend Pri
1	117156 LASER MARKED	D4804-041 BIPOD ASSEMBLY	12/23/2014 Yes 12/23/2014		1.00 ✓	\$4.00	\$4.00
						Line Total:	\$4.00
2	121379 LASER MARKED	D4868-042 LEG ASSEMBLY	12/23/2014 Yes 12/23/2014		2.00	\$4.00	\$8.00
						Line Total:	\$8.00
3	117021 LASER MARKED	D4803-041 BAR ASSEMBLY	12/23/2014 Yes 12/23/2014		2.00	\$4.00	\$8.00

Note:

12/18/2014